W	ork	Order	ID	57937



Page 1

April 20, 2010 3:38:09 PM Item ID: Revision ID: Item Name: Bushing **Start Date: Required Date:** 07/05/2010

D3907-1

20/04/2010 **Start Oty: 40.00** Reg'd Otv: 40.00

Cust Item ID:

Customer:

Setup Start

Run

Stop



Reference:

Process Plan: Approvals:

QC:

Date: 10-4-21 Tooling:

Date: _____

Accept

SPC (Y/N):

Date:

Date:

Start

Stop

Sequence ID/ Work Center ID Operation Description

Revision Nbr

Α

Set Up/ **Run Hours** Draw Number

Plan Draw Rev. Code

Accept Qty

Reject Reject Otv

Insp. Number Stamp

D3907 100

Draw Nbr

Hardinge

Hardinge CNC Lathe Small

Memo

Machine as per Folio FA823 & Dwg D3907

Dwg Rev: A folio Rev: A A Deburr

0.00

0.00

JL 10/04/28

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

JL 10/04/28

0.00

Memo

Dart Aerospace

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Ni-					-					
18.										
Part No	•	PAR #:	Fault Cate	gory:	NCR: Ye	s No DO	QA:	Date:		
					QA: N/C Closed: Date:					
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC	Corrective Action Section B			Verit	ication	Approval	Approval	
	J. L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	ction C	Chief Eng	QC Inspector	

Work Order ID 57937

April 20, 2010 3:38:09 PM



Page 2

Item ID:

D3907-1

Revision ID:

Item Name:

Bushing

Start Date:

20/04/2010



Accept



Setup Start

Stop



Required Date: 07/05/2010 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:

QC:

Start Qty: 40.00

Date: _____

Date:_____

Tooling:

SPC (Y/N):

Date:

Date:

Draw

Start Run

Stop



Sequence ID/ **Work Center ID**

120

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

0.00

Draw Number 4.28

Cust Item ID:

Customer:

Rev.

Code

Plan

Accept Qty

Reject **Qty**

Reject Number Stamp

Insp.

130

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

0.00

140

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/04/29 XJ

W/O:		WORK ORDER CHANGES									
DATE	STEP		PR	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	in the second										
Part No:		P	AR #:	Fault Cat	egory:	NCF	_ Date: _				
	R	esolution:	·	Dispositi	Disposition: Q					Date: _	
NCR:				WORK ORI	DER NON-CONFO	RMANCE	(NCR)		***************************************	
DATE	STEP	Description	of NC	Corrective Action Section B			Verifica			Approval	Approval
	J	Section A		Initial Chief Eng	Action Descript Chief Eng	ion	on Sign & Date		on C	Chief Eng	QC Inspector
		·									

				1 1							

Picklist Print

April 20, 2010 3:38:13 PM

Work Order ID: 57937

Parent Item: D3907-1

Parent Item Name: Bushing

Comments:



Start Date: 20/04/2010

Required Date: 07/05/2010

Page 1

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	31.4500	1.2000			

304 ROUND BAR 0.375

Warehouse	Loc Oty	Loc Code		
Location				
Main Warehouse				
MAT029	31.45			, ,/
113325	7.45		1.2	JL 10/04/28
114356	24			

W/O:			ES			. .				
DATE	STEP	PRO	OCEDURE CHA	NGE	.	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #:			Fault Cate	gory:	NCR: Yes No DQA: Date:					
			Disposition: QA: N/C Closed: Date							
NCR:			WORK ORD	ER NON-CONFORMA	ANCE ((NCR)			• • • • • • • • • • • • • • • • • • • •	-
DATE	STEP	Description of NC		ion B	Verification			Approval	Approval	
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
							1			
										 - -

DART AEROSPACE LTD	Work Order:	57937
Description: Bushing	Part Number:	D3907-1
Inspection Dwg: D3907 Rev: A		Page 1 of 1

Inspection Dwg:	D3907 Rev:	<u> </u>				Page 1 of 1
	FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST	
	X	# _	le	Proto	otype	
Drawing Dimension	Tolerance	Dimension	Accept	Reject	Method of Inspection	Comments
	1 .010 -1 10					
Ø0.375	- +0.006/-0.00 1	.3748	V	-		
0.25	+/-0.030	250	V			
0.059	+/-0.010	.059	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \			
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easured by:		Audited by:	<i>K</i>	-	Prototype App	
Date: /C	104/28	Date:	10.4.	L 8		Date: N/A
	Change				Revised	by Approve
A 09.05.20 N	lew Issue				KJ	9X8

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
:														
Part No	Part No: PAR #: _		Fault Cat	egory:	NCR:	1								
	Re	esolution:	Dispositi	on:	QA: N	/C Clo	sed:		Date:					
NCR:		1	WORK ORE	DER NON-CONFORM	MANCE (NCR)								
DATE	STEP	Description of NC Section A	Initial	Action Description	Section B on Sign 8		Verification Section C		Approval Chief Eng	Approval QC Inspector				
			Chief Eng	Chief Eng .	-	Date								

SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK GRDER NO. 57937 BS/10-4-20 0.059 Ø0.375 REF Ø0.257 **D3907-1 BUSHING SECTION A-A**C5-1 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD REF DART SPEC M304R A NEW ISSUE AJS 09.03.11 DESCRIPTION OR: AISI 304/316 STAINLESS STEEL BAR REV. DATE REF DART SPEC M304B DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA 2) FINISH: NONE CHECKED DRAWING NO. 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED REV. A MEG. APPR. D3907 SHEET 1 OF 1 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX APPROVED TITLE SCALE 6) IDENTIFICATION: N/A DE APPR. BUSHING (BASKET REPAIR) NTS 7) WEIGHT: N/A COPYRIGHT © 2009 BY DART AEROSPACE LTD

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60) 1061 -250 YOR AN EMBOOS OF CO 160 OF CONSCULLED LA WORK OF REPRISE OF COMMON SECTION 1-111 (
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W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			· · · · · · · · · · · · · · · · · · ·						Prod Mgr				
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes I	No DQA : Date :						
		solution:											
NCR:			WORK ORDI	ER NON-CONFORI	MANCE	(NCR							
DATE	STEP	Description of NC	Description of NC Corrective Action				Verific	fication Approva		Approval			
	SIEP	Section A	Initial Chief Eng	Action Descriptio Chief Eng	n	Sign & Date	Secti		Chief Eng	QC Inspector			
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			4.44										